

Work Order ID 105593

Thursday, August 08, 2013 12:46:59 PM

105593

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Item ID: D2596

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web, 205 Skidtube

Start Date: 8/8/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/15/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MLJ*Date: *13-08-08* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2596	Rev D								
100		0.00							
100	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr								
110	Chemical Conversion Coat per QSI005 4.1	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

*13-8-8**J.D. 13-8-12**6**BB 13/08/12*

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Approvals: Process Plan: Date:

Run Start ***NR1***

QC: Date:

Stop ***NR2***

Tooling:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: 64

0.00

130

Packaging

Memo

0.00

Packaging

6 13/08/12

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML3 13-08-14

QC 13-8-13

Picklist Print

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Work Order ID: 105593

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Parent Item: D2596

D2596

Parent Item Name: Web. 205 Skidtube

Start Date: 8/8/2013

Required Date: 8/15/2013

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: D99.02.02Changed QA to QC. Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	108.0000	1	6			

D2500-3-100

Ext'n - 'I' Beam Web 4"

**

Location

LG

84873

89110

Loc Qty

108

4

104

Loc Code

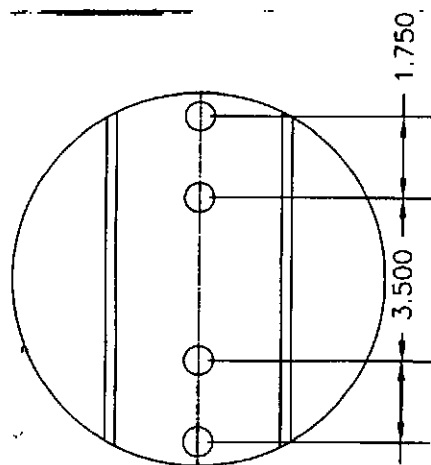
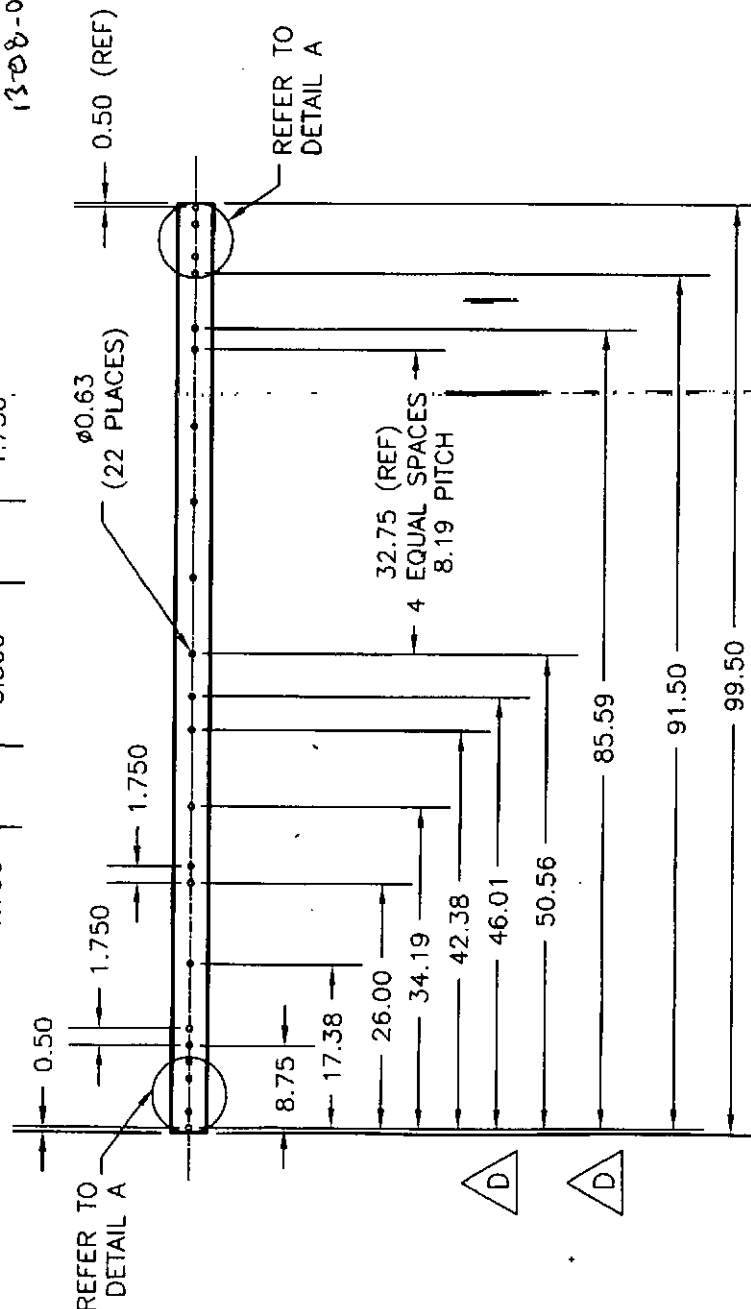
(Handwritten signature)

1388

DL

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2596	REV. 0 SHEET 1 OF 1
DATE 07.04.17	TITLE 205 WEB		SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

RELEASED
07.06.18105593 MLS
1308-08**DETAIL A**
SCALE 1:4**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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